

# Work Order ID 76740

**\*76740\***

Page 1

Monday, November 21, 2011 9:53:46 AM

Item ID: D3806-5 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Bar

Start Date: 11/21/2011 Start Qty: 50.00 **\*50\*** Cust Item ID:  
 Required Date: 12/20/2011 Req'd Qty: 50.00 **\*50\*** Customer:

## Reference:

Approvals: Process Plan: *[Signature]* Date: 11/21 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***  
 Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3806	B								

100

0.00

**\*100\***

Cold Saw

Hyd Mech

### Memo

Cut blanks at 44.50"

\*\*\*FOR CLAMPING PURPOSE WHEN WELDING 1.00" WAS ADDED ON  
 LENGTH AND IT WILL BE CUT TO LENGTH AFTER WELDING\*\*\*

0.00

0.00

110

**\*110\***

HAAS 1

HAAS CNC vertical machine #1

### Memo

1-Mill as per folio FB070 & dwg

FOLIO REV: AA

DWG REV: R

2-Deburr as required

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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 Item Name: Bar

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 Required Date: 12/20/2011 Req'd Qty: 50.00 \*50\* Customer:

## Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120	QC2- Inspect parts off machine FAI/FAIB	0.00							
*120*									
QC	Memo	0.00							
Quality Control	***FOR CLAMPING PURPOSE WHEN WELDING 1.00" WAS ADDED ON, LENGTH AND IT WILL BE CUT TO LENGTH AFTER WELDING***								

130	QC8- Inspect parts - second check	0.00							
*130*									
QC	Memo	0.00							
Quality Control									

133	Weld per dwg A/R Hardcoat S.S. Batch: _____	0.00							
*133*									
Large Fab	Memo	0.00							
Large Fab	1- On D3806-5, fill cut outs with hardcoat welding rod as per dwg D3805 2059 B Hardcoat Welding Rod BATCH#: _____								
	***CUT BAR TO FINISH SIZE AFTER WELDING HARD COAT***								

on assembly w/o u

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Monday, November 21, 2011 9:53:47 AM

Item ID: D3806-5 Accept **\*N900040100\*** Setup Start **\*NS1\***  
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 Item Name: Bar  
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 Required Date: 12/20/2011 Req'd Qty: 50.00 **\*50\*** Customer:

## Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
136 <b>*136*</b> QC Quality Control	QC10- Inspect visual per QSI004- ground welds  Memo	0.00  0.00	on assembly w/o u						
137 <b>*137*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00							
140 <b>*140*</b> Packaging Packaging	Identify as per dwg & Stock Location: <u>W/A 038</u>  Memo	0.00  0.00							

Q 11-18-11 (KSO)

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**NOTE:** Date & initial all entries

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mt  
11-12-0

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# Picklist Print

Monday, November 21, 2011 9:53:55 AM

Page 1

Work Order ID: 76740

**\*76740\***

Parent Item: D3806-5

**\*D3806-5\***

Parent Item Name: Bar

Start Date: 11/21/2011

Required Date: 12/20/2011

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP Rev:A 08-07-21 new issue DD verified by:ec  
 IPP Rev:B 08-09-23 redesign DD verified by:EC  
 IPP Rev:C 08-12-05 chg mat. thickness DD verified by:EC IPP Rev:D  
 11.10.04 rev.b as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.500X2.500		Purchased	No			100	f	52.4970	3.666	192.9474			

**\*M304B0 500X2 500\***

304 BAR 500 x 2.50

**\*\***

500 X 2.50

Location	Loc Qty	Loc Code
MAT050	52.497	
112764	8.312	
116135	0.375	
117685	4.4	
119231	39.41	

M11915 9 X 200

amp 11/11/26

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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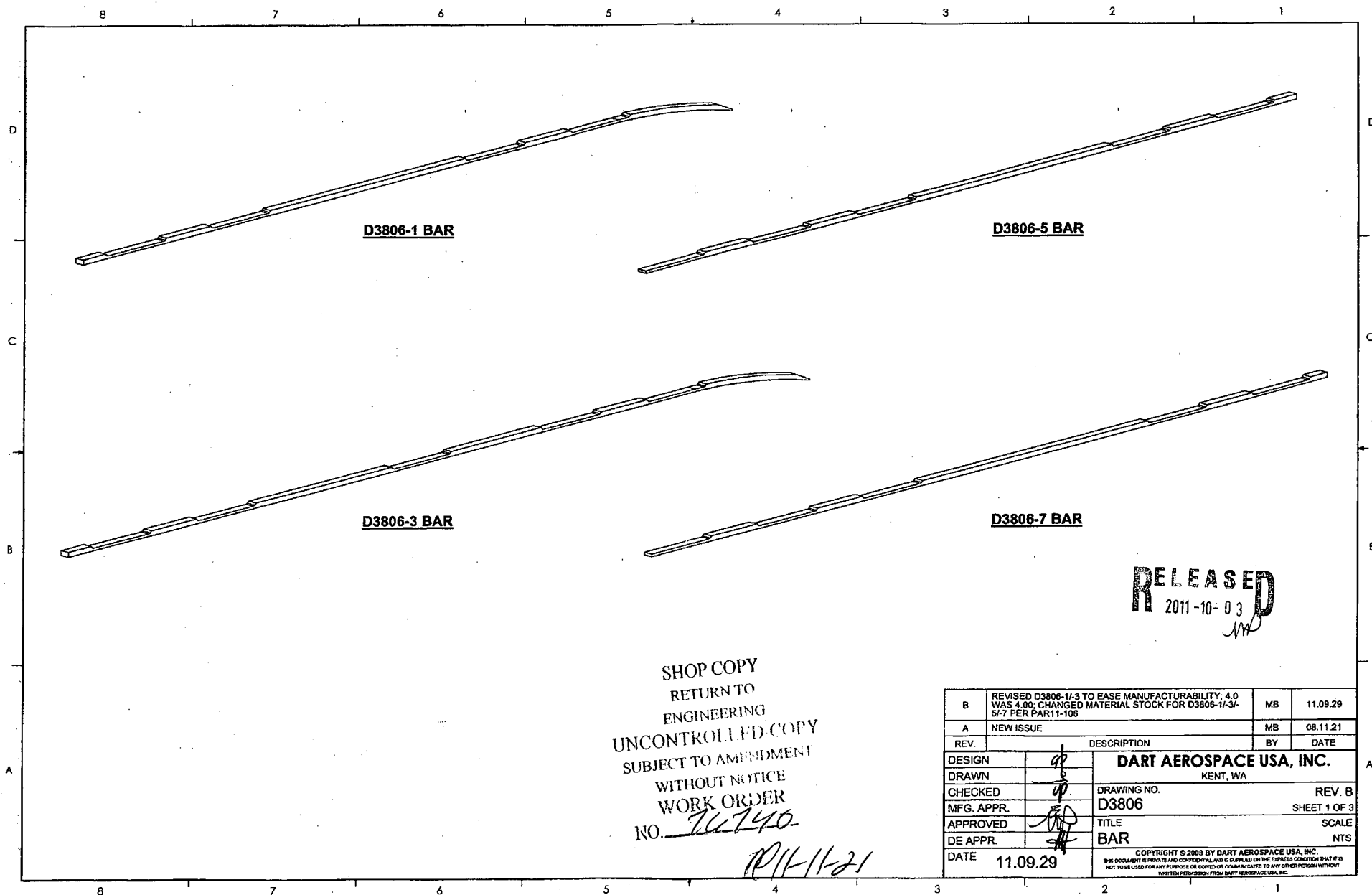
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RELEASED  
2011-10-03  
*MB*

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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 76740

*11/11/21*

B	REVISED D3806-1/3 TO EASE MANUFACTURABILITY; 4.0 WAS 4.00; CHANGED MATERIAL STOCK FOR D3806-1/3/5/7 PER PART 1-108		MB	11.09.29
A	NEW ISSUE		MB	08.11.21
REV.	DESCRIPTION		BY	DATE
DESIGN	<i>JP</i>		DART AEROSPACE USA, INC. KENT, WA	
DRAWN	<i>JP</i>		DRAWING NO. D3806 REV. B	
CHECKED	<i>JP</i>		SHEET 1 OF 3	
MFG. APPR.	<i>JP</i>		TITLE BAR SCALE NTS	
APPROVED	<i>JP</i>		DATE 11.09.29	
DE APPR.	<i>JP</i>		<small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS LOANED TO YOU ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER OR BY ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

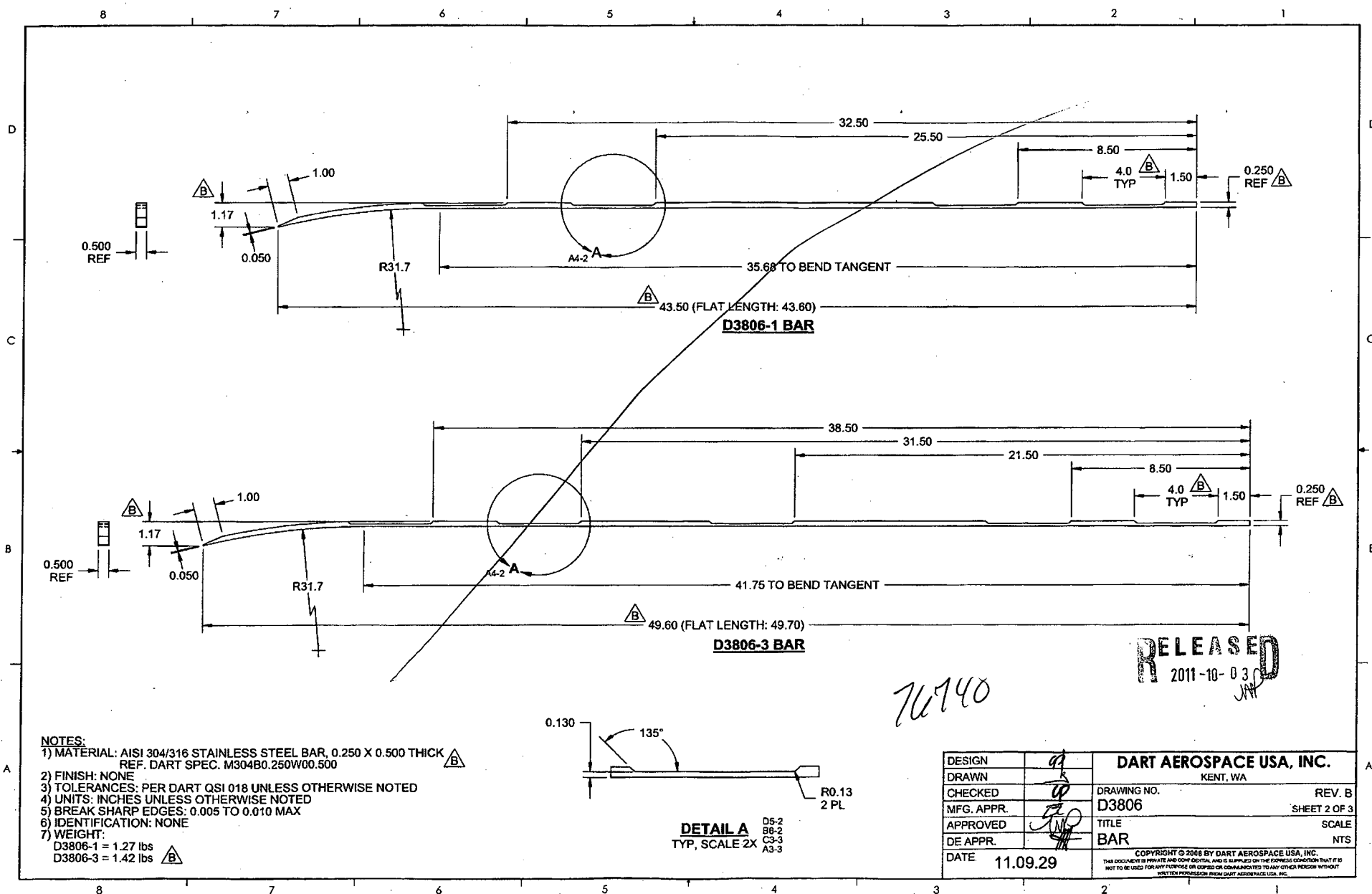
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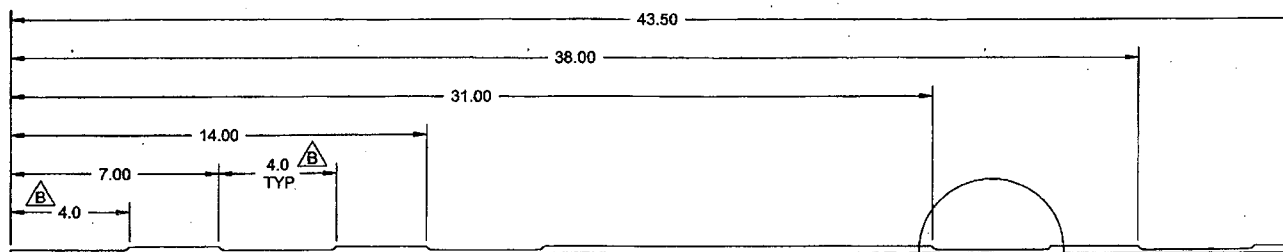
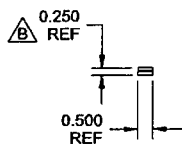
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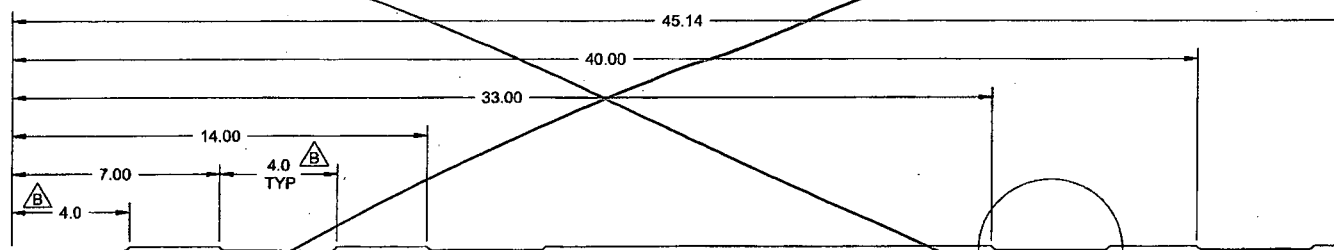
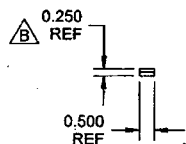
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**D3806-5 BAR**



**D3806-7 BAR**

RELEASED  
2011-10-03

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.250 X 0.500 THICK  
REF. DART SPEC. M304B0.250W00.500
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT:  
D3806-5 = 1.22 lbs  
D3806-7 = 1.28 lbs

76740

DESIGN		<b>DART AEROSPACE USA, INC.</b>	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3806	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BAR	NTS
DATE	11.09.29	<small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR TRANSMITTED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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